

DART AEROSPACE LTD	Work Order:	2986
Description: Bracket ass'y	Part Number:	D2804-043041
Dwg: D2804 rev.A1	Qty:	1

04.11.30

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	W	04.11.30	1
2	STORES	Pick: Qty Part Number Description Batch 1 D2804-1 Bracket B21977 1 D2805-3 D2805-1 Stop CP 04.11.30 B14243 1 D2809 Bushing B17794	B	04.11.30	1
3	METAL	Press D2805-3 into arm as per Dwg D2804 D2805-1 CP 04.11.30	B	04.11.30	1
4	QC	Inspect Level 5	CP	04.11.30	1
5	FINISHING	Powder coat white (4.3.5.1) per QSK005	M	04.12.01	1
6	QC	Inspect Level 3	B	04.12.01	1
3	METAL	Press D2809 into arm as per Dwg D2804	B	04.11.30	1
7	STORES	Pick: Qty Part Number Description Batch 12 AN3-16A Bolt M14823 24 AN960JD10 Washer M15102 12 MS21042L3 Nut M15066	B	04.11.30	1
8	METAL	Assemble as per DWG D2804	B	04.11.30	1
9	QC	Inspect Level 5	CP	04.12.01	1
10	STORES	Identify and stock	CL	04.12.01	1
11	EXPEDITING	Close W/O Cost / part: 68.31 540 04/12/02 (1)	CP	04.12.03	1

Rev	Date	Change	Revised By	Approved
A	01.04.06	New Issue	EC	
B	01.04.26	Re format	EC	EC

Resume Steps
B

RELEASED
EC 01.04.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

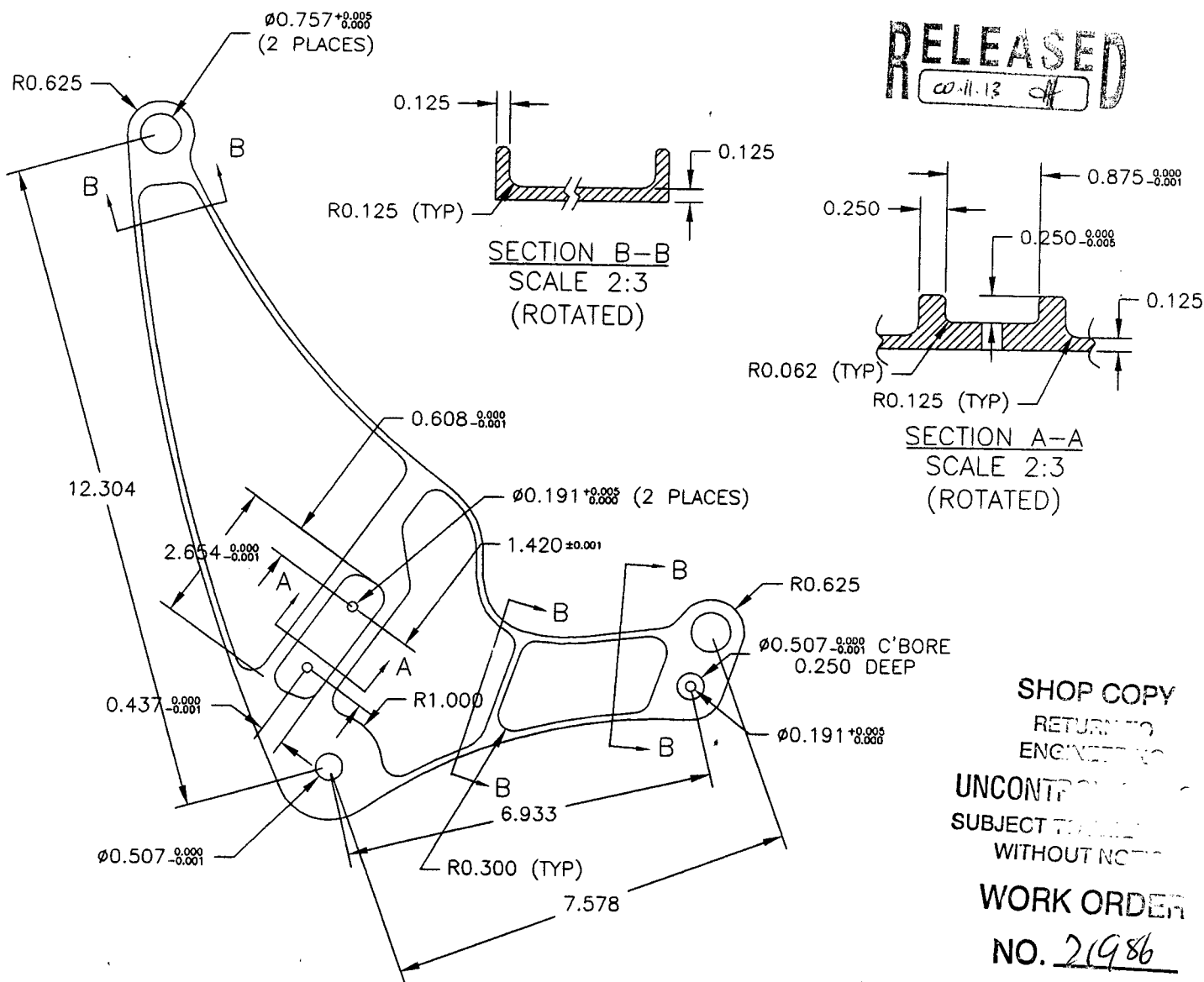
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2804	REV. A SHEET 1 OF 2
DATE 00.11.07		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
A1	01.03.14	ADD D2804-043/-044	

RELEASED
00.11.13



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO
WITHOUT NOTICE
WORK ORDER
NO. 21986

D2804-1 (SHOWN)
D2804-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2804-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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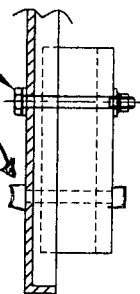


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED #	DRAWING NO. D2804	REV. A SHEET 2 OF 2
DATE 00.11.07	TITLE STA 155 BRACKET		SCALE 1:3

RELEASED
00.11.13

AN3-16A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(2 PLACE)

UP 09.11.30



SECTION C-C
SCALE 1:3
(ROTATED)

USE D2804-1 FOR D2804-041 & -043
USE D2804-2 FOR D2804-042 & -044

USE D2805-3 FOR D2804-043
USE D2805-4 FOR D2804-044
USE D2805-1 FOR D2804-041
USE D2805-2 FOR D2804-042
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO
POWDER COAT

SHOP COPY
RETURNED

UNCL
SUBJ
WITH

D2804-041 ASSEMBLY (SHOWN) → D2804-043 SIMILAR
D2804-042 ASSEMBLY (OPPOSITE) → D2804-044 SIMILAR



WORK ON
21986

NO FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY
SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX
(4.3.5.8) PER DART QSI 005 4.3

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 30, 2004
12:24 pm

Work Order No	: 0021986	Department Code:	
Project Name	: D2804-043	Burden Flags	: NNNNNNN
Project For	: WK449	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2804-043	Invoice Number	:
Description	: STA 155 Bracket Ass'y LH	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 1	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 11-30-04	Actual Margin	: 0.000%
Est Finish Date	: 11-30-04		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
=====	=====	=====	=====	=====	=====
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====	=====	=====	=====		
Burden	: 0.00	0.00	0.00		
=====	=====	=====	=====		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00